

01–120 Facing cylinder crankcase parting surface

Data

Height of cylinder crankcase when new	242.9–242.8
Minimum height following required removal of material	242.5
Permissible unevenness of parting surface	in longitudinal direction 0.10
	in transverse direction 0.05
Permissible roughness of upper parting surface	0.006–0.016
Permissible deviation in parallel of upper parting surface in relation to longitudinal direction	0.1
Pressure-test with air under water in bar gauge pressure	2.0
Chamfer of cylinder bores	refer to note

Note

Prior to facing, check piston standout. Do not exceed piston standout of 0.9 mm (03–316).

Chamfer cylinder bores after facing.

If the cylinder crankcase parting surface has been reconditioned, reset the timing (05–215).

